

Work Order ID 94316

94316

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December-07-12 9:06:37 AM

Item ID: D350-607-041A

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/11/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Rework

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-1	A								
DSI 9473									
100		0.00							
100	DOCUMENT CONTROL								
DC		0.00							
Document Control	Memo Photocopy bluefile & type labels per PPPD350-607-041A CHG002								
110	Pick Kit	0.00							
110		0.00							
Packaging	Memo								
Packaging	PULL FROM STOCK: 1 X D350-607-041 B 89629 CHG009								

MLJ 12-12-10

[Signature] 12-12-07

[Signature] 12-12-07

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Item ID: D350-607-041A

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/11/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Run Start ***NR1***

Stop ***NR2***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

REMOVE PROP ARM D2332-041
ADN RETURN TO STOCK B

84006

JS 12.12.07

121

0.00

121

Large Fab

Memo

0.00

Large Fab

GRIND FLUSH D2327-3 BUSHINGS AT BOTH ENDS OF BASKET
TRIM STEEL MESH LOCALLY A/R
TRANSFER MARK AND DRILL 2 X 0.194 HOLES THRU BASKET LID &
BASE SQUARE TUBING PER
DETAIL L

JS 12.12.07

122

0.00

122

HandFinish

Hand Finishing

Memo

TOUCH UP

→ QS
Sm 12/26/12

(DAS 16) *12/12/10* *(40)*

DAS DART AEROSPACE		HAWKESBURY, ONT CANADA K6A 1K9 TEL: 519-882-5200 FAX: 519-882-6330	
PATENT	N/A	Q/C	CHG009
P/N	D350-607-041/-042	STC	SH94-14
DESC	Heli-Utility-Basket	STC	SR00213NY
LOT	B89629	STC	
MODEL	AS350/355	STC	
TC APPROVAL # 09-89		MADE IN CANADA	

02729-4

1 of BR 12/12/10

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Item ID: D350-607-041A Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket (Automatic Lid Opener)
 Start Date: 12/07/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/11/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC3- Inspect Part Finish	0.00							
123									
QC	Memo	0.00							
Quality Control									
124		0.00							
124									
Small Fab	Memo	0.00							
Small Fab	RE-ASSEMBLE PER DRWG.								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control	*****Ensure label for weight capacity is correct*****								

DAS
16
12/12/10

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Item ID: D350-607-041A Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Utility-Basket (Automatic Lid Opener)
Start Date: 12/07/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/11/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging	Pick Kit	0.00							
Packaging	Memo ENSURE ORIGINAL KIT IS IN BOX	0.00							12/12/10 DAS 20 9-89
150 *150* QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00							12/12/10 DAS 20 9-89
160 *160* Packaging	Packaging	0.00							
Packaging	Memo RE-PACKAGE PER PPP USING NEW B/N Identify and pack for shipping as per PPP D350-607-041A Location: _____	0.00							12/12/10 DAS 06 9-89

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Item ID: D350-607-041A Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Utility-Basket (Automatic Lid Opener)
Start Date: 12/07/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/11/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/12/20 *[Signature]*

12-20-12

Picklist Print

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Work Order ID: 94316

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12

Required Date: 12/11/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
 10.01.18 verified by:EC IPP Rev:C as per ecn10-545 DD 10.04.19 verified by:EC IPP
 Rev:D 10.10.18 remove D350-607-141 and added individual parts of D350-607-141 in DD
 verf:JLM IPP REV:E 12.07.24 AS PER ECN 12-603 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 NUT		Purchased	No			110	Each	75.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST342		75							
				121349		2							
				122800		48							
				123900		25							
AN3C11A BOLT		Purchased	No			110	Each	38.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		38							
				119798		8							
				122808		30							
D2332-041 Lid Prop Assembly 6.69" long		Manufactured	No				Each	17.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		17							
				89226		9							
				90057		2							
				90735		6							
D350-607-041 Heli-Utility-Basket, LH		Manufactured	No				Each	3.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				BSKT		2							
				89093		1							
				89629		1							
				FG104		1							
				82160		1							

Picklist Print

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Work Order ID: 94316

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12

Required Date: 12/11/12

Start Qty: 1.00

Required Qty: 1.00

D3953-1
Gas Spring Bracket

Manufactured No

110 Each 5.0000

2

2

Location

Loc Qty

Loc Code

ST076

5

53760

5

53760

D3953-11
Gas Spring Spacer

Manufactured No

110 Each 9.0000

2

2

Location

Loc Qty

Loc Code

ST076

9

87089

9

87089

D3953-13
Gas Spring Spacer

Manufactured No

110 Each 14.0000

2

2

Location

Loc Qty

Loc Code

ST076

14

52761

2

89247

12

52761

D3953-3
Gas Spring Stud, Lid

Manufactured No

110 Each 41.0000

2

2

Location

Loc Qty

Loc Code

GA

1

87592

1

ST076

40

88494

26

89337

14

89337

D3953-5
Gas Spring Stud, Base

Manufactured No

110 Each 26.0000

2

2

Location

Loc Qty

Loc Code

ST076

26

85958

6

86593

20

80908

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Work Order ID: 94316

Parent Item: D350-607-041A

Start Date: 12/07/12

Required Date: 12/11/12

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No
Spring Spacer

110 Each 45.0000

2

2

Location

Loc Qty

Loc Code

ST076

45

87444

9

88393

24

89248

12

87444

D3953-9 Manufactured No
Gas Spring Washer

110 Each 39.0000

4

4

Location

Loc Qty

Loc Code

ST076

39

88462

9

89307

30

88462

D3969-1 Manufactured No
Spring (Basket Lid)

110 Each 9.0000

2

2

Location

Loc Qty

Loc Code

ST262

9

73523

1

84424

8

84424

MS21043-3 Purchased No
Nut

110 Each 860.0000

8

8

Location

Loc Qty

Loc Code

FG

72

103691

72

FP001

64

123525

64

ST315

724

118077

2

118614

7

118686

30

119758

20

121255

20

122993

145

123899

500

123899

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Shop Packet Print

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Work Order ID: 94316

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12

Required Date: 12/11/12

Start Qty: 1.00

Required Qty: 1.00

MS24665-2-12

Purchased No

110

Each

94.0000

4

4

COTTER PIN

Location

Loc Qty

Loc Code

ST299

94

118078

94

118078

NAS1149C0332R

Purchased No

110

Each

9,414.0000

8

8

Washer

Location

Loc Qty

Loc Code

FP001

15

123355

15

ST292

9399

123248

65

123759

9334

123759

NAS1149C0432R

Purchased No

110

Each

3,626.0000

4

4

Washer

Location

Loc Qty

Loc Code

GA

106

121255

106

ST292

3520

117291

40

119124

480

122441

3000

119124

ANB C 16A.

122814

H.

(4)

BL 12/12/12.

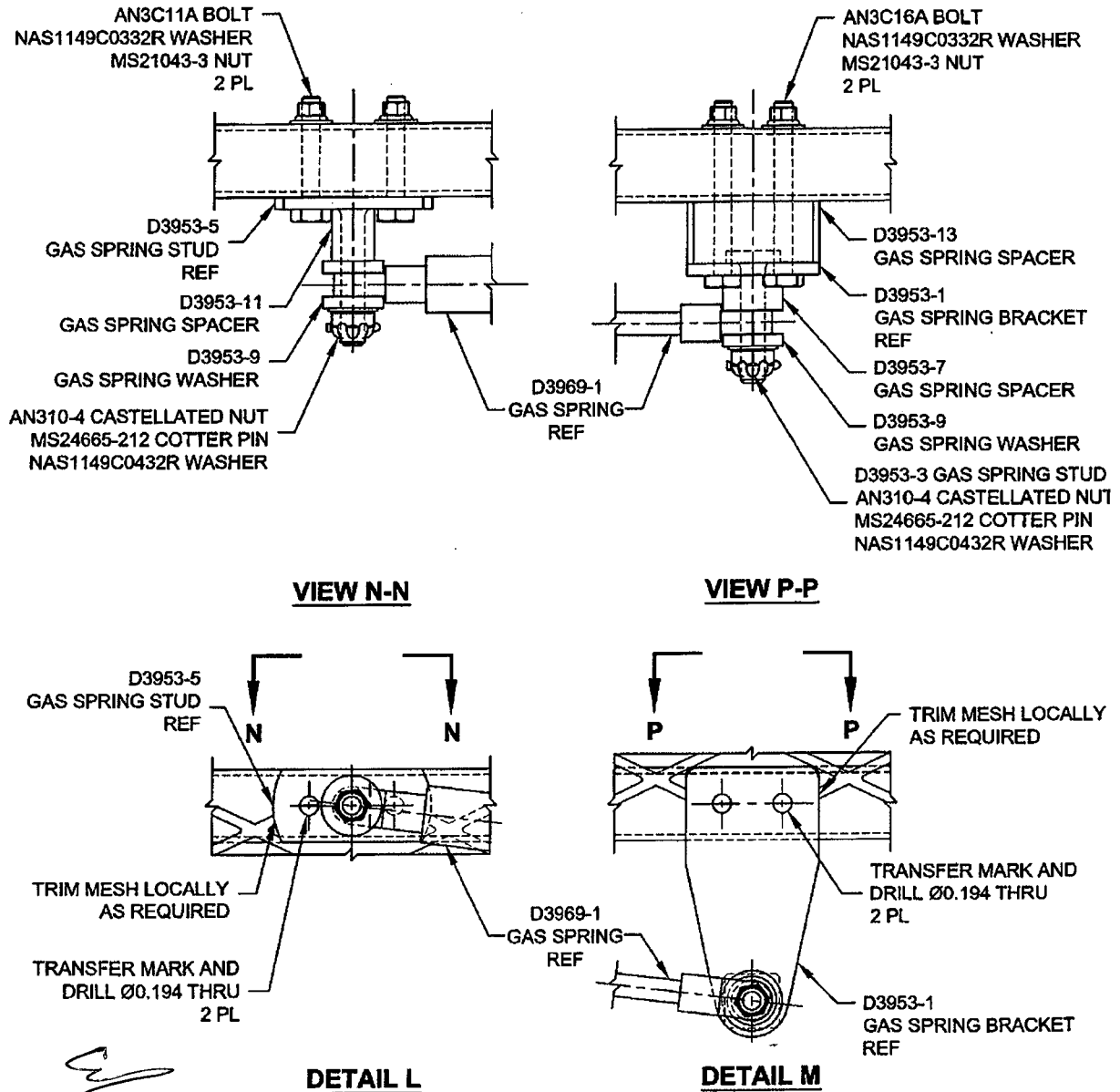


Figure 8b - Automatic Lid Opener Installation

2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the responsibility of the installer. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D350-607.

3.0 INSTALLATION PROCEDURE

For installation of D350-607-041/-041A/-043/-043A/-045/-045A/-047/-047A *Heli-Utility-Basket™*.

- 3.1 **NOTE:** For aircraft equipped with high gear, the Dart *Heli-Utility-Basket™* is compatible with Dart D350-591 high-gear steps. The D350-591 step height must be set as shown in Figure 1 to ensure that the cargo doors will open with the basket installed. For aircraft equipped with low gear, the Dart *Heli-Utility-Basket™* is **not** compatible with Dart D350-591 low gear steps; any Dart low gear step will have to be removed before basket installation.
- 3.2 The D350-607-041/-043/-045/-047 *Heli-Utility-Basket™* may be installed on either the LH or RH side of the aircraft. For RH installations, the D2332-041 Prop Assembly should be moved to the aft end of the basket. Use existing hardware and ensure nuts face aft.
- 3.3 Install the D2732-030 Rubber Cushions, D2230-1 Lugs and D2324 Strut onto the basket as shown in Figures 2 and 3, using the AN4 hardware shown.
NOTE: The AN4-15A bolts may be replaced with a stainless steel positive locking quick release pin with a minimum double shear strength of 2400 lbs and with a 1.0 inch grip length and 0.25 inch diameter (Avibank: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S; MS Number: MS17984C410, MS17985C410, MS17986C410, MS17987C410)
- 3.4 Present the basket to the crosstubes. Propping the basket at the appropriate height can facilitate installation. If the basket is being installed on high gear with Dart D350-591 steps, temporarily place a 0.063" (1.6mm) shim on the step and rest the basket on the shim. Remove shims after bolts are torqued.
- 3.5 Attach the basket with the D2230-3 Clamps and AN4 hardware shown in Figure 2 and 3. Leave bolts loose to allow for adjustment.
- 3.6 Tighten clamp bolts once height is positioned properly. Do not exceed torque of 60 in-lb (6.8 Nm) on the nuts. **CAUTION:** Over-torquing the nuts could lead to structural damage of the clamps.

4.0 INSTALLATION OF OPTIONAL KITS

4.1 D350-607-141 AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)

NOTE: Once this modification is complete you will not be able to re-install the D2332-041 Prop Arm.

- 4.1.1 Remove the D2332-041 Prop Arm.
- 4.1.2 Grind Flush the D2327-3 Spacer Bushing on both ends of the Basket as shown in Figure 8a (it is permissible to grind all 4 Spacers Flush). Touch up paint Per ICA-D350-607 Section 5.1 Item 4.
- 4.1.3 Locate the D3953-1 Gas Spring Bracket as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket lid square tube structure as shown in Detail M. Install the D3953-1 Gas Spring Bracket & D3953-13 Gas Spring Spacer using 2X AN3C16A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 NUT as Shown in View P-P.

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.